



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2855-5**Job Sheet 204081**

S245866

Part No: D2855-5

Job Qty: 60 pcs

Part Name: Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/2/19

Job Tracking No:

Due Date: 12/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 17.05.10 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	60 pcs	12/30/19	12/30/19	0.00	0.00	Purchasing - 1		JAN 08 2020
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	60 pcs	12/30/19	12/30/19	0.00	0.00	Packaging 2 - 1 - B4B		JAN 08 2020
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 -		

DAS
82
9-89DAS
82
9-89

Container No: S245866



Part: D2855-5

Job No: 204081

Serial No/Batch: S245866

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/09/20

Plex 12/24/19 10:42 AM Dart.Guerin.Kimberley

					B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	60 pcs	12/30/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	81
					QC 6 - 40	9-89
					QC 6 - 81	JAN 0 8 2020
130	Small Fab - 2 - B4B	60 pcs	12/30/19	0.00 2.10	Small Fab - 1 - B4B	DAS
					Small Fab - 2 - B4B	58
					Small Fab - 3 - B4B	9-89
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
142	NV5000 - 1 - B4B	60 pcs	12/30/19	1.00 5.00	NV5000 - 1 - B4B	12/24/19 20-0208
143	QC 5	60 pcs	12/30/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	

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					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	PD 200226
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150	Powdercoat - 1 White GI(A)- B4B	60 pcs	12/30/19	0.00 0.74	Powdercoat - 1 - B4B	BEB 20-02-05
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	60 pcs	12/30/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170	Small Fab - 3 - B4B	60 pcs	12/30/19	0.00 2.10	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	BEB 20-03-10
180	QC 5	60 pcs	12/30/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	DAS
					QC 5 - 24	81
					QC 5 - 3	9-89
					QC 5 - 43	
					QC 5 - 49	
					Plex 12/24/19 10:42 AM Dart.Guerin.Kimberley	

					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					190 Packaging 3-1 - Stock - B4B	60 pcs
Packaging 3 - 2 - B4B						
Packaging 3 - 3 - B4B						
Packaging 3 - 4 - B4B						
Packaging 3 - 5 - B4B						
Packaging 3 - 6 - B4B						
Packaging 3 - 7 - B4B						
Packaging 3 - 8 - B4B						
Packaging 3 - 9 - B4B						
Packaging 3 - 10 - B4B						
Packaging 3 - 11 - B4B						
Packaging 3 - 12 - B4B						
Packaging 3 - 13 - B4B						
Packaging 3 - 14 - B4B						
Packaging 3 - 15 - B4B						
Packaging 3 - 16 - B4B						
Packaging 3 - 17 - B4B						
Packaging 3 - 18 - B4B						
Packaging 3 - 19 - B4B						
Packaging 3 - 20 - B4B						
Packaging 3 - 21 - B4B						
Packaging 3 - 22 - B4B						
Packaging 3 - 23 - B4B						
Packaging 3 - 24 - B4B	JW 004/03/11					
Packaging 3 - 25 - B4B						
Packaging 3 - 26 - B4B						
Packaging 3 - 27 - B4B						
Packaging 3 - 28 -						
					Plex 12/24/19 10:42 AM Dart.Guerin.Kimberley	

				B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DA5
200 QC 21 - SA	60 pcs	12/30/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-8#
				QC 21 - SA - 53	MAD 1 1 2020

Part Op 100 - (Purchasing) Issue P/O: _____ Cast per Dwg D2855 Material Release Note Required Supplier: Metallurgie

Descriptions: SYCA

110 - Receive & Inspect for Damage & Mat'l Certs

120 - QC6- All purchased or subcontracted products

130 - (Small Fab) 1- Drill ONE SIDE ONLY as per Dwg D2855 using DT8235 2- Open hole ONE HOLE to 0.297"

142 - (Manufacture as per dwg) 1- MILL to length as per dwg use DT10248 JAWS 2- Deburr

143 - QC5- Inspect part completeness to step on W/O

150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 7:00 OVEN TEMPERATURE: 320° FINISH TIME: 7:30

160 - QC3- Inspect Part Finish

170 - (Small Fab) Install Insert as per Dwg D2855

180 - QC5- Inspect part completeness to step on W/O

190 - Identify as per dwg & Stock Location: _____

200 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2855P	Cap	60 pcs (1 ea)	100-Purchasing	5243870
ALS7-1032-225	Insert	60 Ea (1 ea)	170-Small Fab - 3 - B4B	5038208

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2855P	60	0	0
170-Small Fab - 3 - B4B	ALS7-1032-225	60	1,164	0

Part Specifications
Specifications could not be found.

Plex 12/24/19 10:42 AM Dart.Guerin.Kimberley



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045294**



Supplier: MES001-VC
Metallurgie SYCA
500 Principale,
St. Dominique
QC
J0H 1L0 Canada
Phone: 450-261-0853
Fax: 450-261-0894

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045294

PO Date: 12/3/19

Due Date: 1/10/20

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Fedex Economy

Pymt Terms: Net 30

Freight Terms: Collect

Special Comments:

REVISED

DEC 17 2019

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		D2855P	D2855 Rev C			Cap - as per Dwg D2855 Rev. C wo 204081 & 204155	Firmed	-	1/10/20	120 pcs	0 pcs	120 pcs	\$19.00/pcs	\$2,280.00
Line Item Note note price include certification fees work order 204081 & 204155														
Grand Total:													\$2,280.00	

*122
PCS
GUB*

JAN 08 2020

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Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

CL

Plex 12/17/19 7:29 AM Dart.Lavoie.Chantal

METALLURGIE SYCA

Certificate of compliance

This is to certify that the below named items were inspected and tested to approved specification only. Objective evidence is on file to support the verifications and tests and can be made available at our facilities on request unless otherwise noted.

Customer name: **DART AEROSPACE**

Delivery address: **1270, Aberdeen Street**

Hawksbury, ON

Purchase Order # : **POHB045294**

DAS
82
9-89

JAN 0 8 2020

Quantity supplied

Part number

Part name

120
122
DAS
82
9-89

D -2855

CAP D-2855

Signed by: _____ Roxanne Grenier

Date: _____ 08/01/2020

Métallurgie Syca

500, Principale, Saint-Dominique, QC J0H 1L0

Tél. (450) 261-0853 Téléc. (450) 261-0894

roxanne@syca.ca

Métallurgie Syca inc

PACKING SLIP

POHB045294

500 RUE PRINCIPALE, ST-DOMINIQUE, QUEBEC J0H 1L0

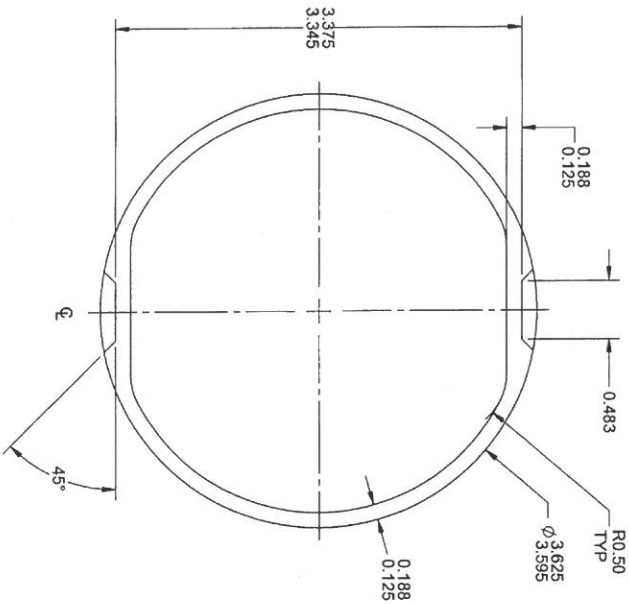
Phone: (450) 261-0853 Fax: (450) 261-0894

Sold to				Ship to				CUST. P.O.	
DART AEROSPACE LTD								POHB045294	
1270, ABERDEEN STREET									
HAWKSBURY, ON									
K6A 1K7									
Phone: (613) 632-9577								Due date	
								Ship via	
Buyer		Salesman		N° TPS	N° TVQ	# account	Transport paid by	Verify per	Page
		ROXANNE		873216006	1204830718				1
# Product	Description			Qty ordered	Qty shipped	Reference no			
D-2855	CAP D-2855			100	120	3396			
CERTIFICAT	Certificat de conformité			1	1				

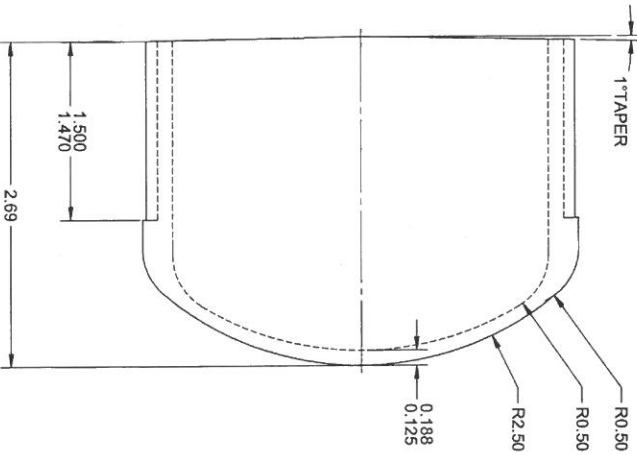
REC
122
PLS
DAS
82
9-20
JAN 08 2020

Comments

Signature _____



D2855C CASTING DETAIL CAP



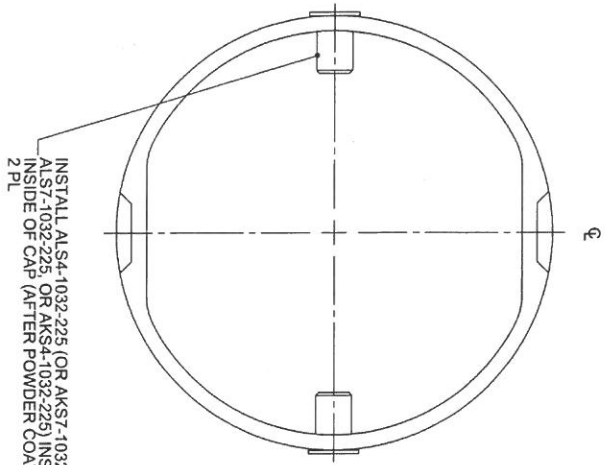
- NOTES:**
- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.62 lbs

RELEASED
2017-05-08
ECN 17-519

APPROVED

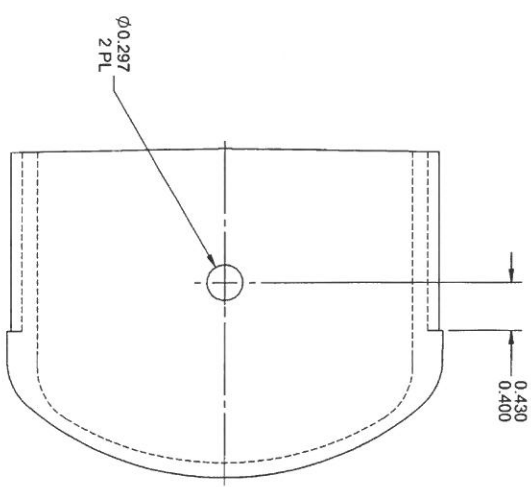
REV.	DESCRIPTION	BY	DATE
C	ADDED D2855-5 (ZN C6-4)	WK	17.03.01
B	DRAWING UPDATED TO CURRENT STANDARDS.	RF	09.06.30
A	NEW ISSUE (WAS D2375 REV. E)	DS	96.12.12
DESIGN	DS	DESCRIPTION	
DRAWN	WK	DART AEROSPACE LTD	
CHECKED	RF	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	JFS	D2855	REV. C
APPROVED	HS	TITLE	SHEET 1 OF 4
DE APPR.	DS	CAP	SCALE
DATE	17.03.01	NTS	

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.



INSTALL ALS4-1032-225 (OR AKS7-1032-225 OR
ALS7-1032-225 OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855 CAP
(MAKE FROM D2855C CASTING)



$\phi 0.297$
2 PL

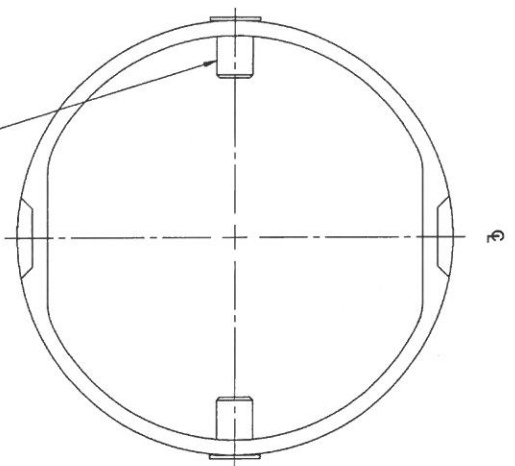
- NOTES:
- 1) MATERIAL: MAKE FROM D2855C
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.63 lbs

RELEASED
2017-05-08

APPROVED

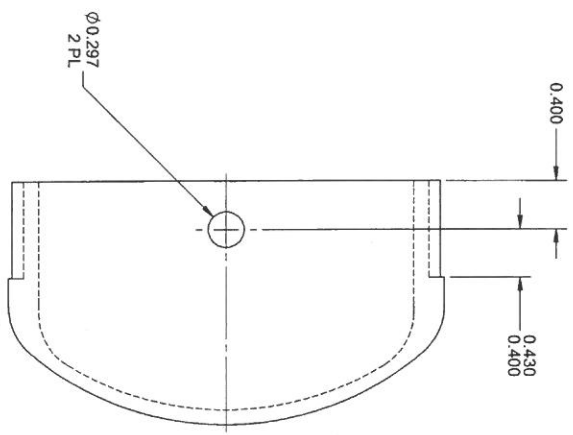
DESIGN	DS	DART AEROSPACE LTD
DRAWN	WK	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO. D2855
MFG. APPR.	JFS	REV. C
APPROVED	HS	SHEET 2 OF 4
DE APPR.	DS	SCALE
DATE	17.03.01	NTS

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INSTALL AL54-1032-225 (OR AKS7-1032-225, OR
AL57-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP
(MAKE FROM D2855C CASTING)



- NOTES:
- 1) MATERIAL: MAKE FROM D2855C OR D2855
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART OSI 005 4.3
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.50 lbs

RELEASED
2017-05-08

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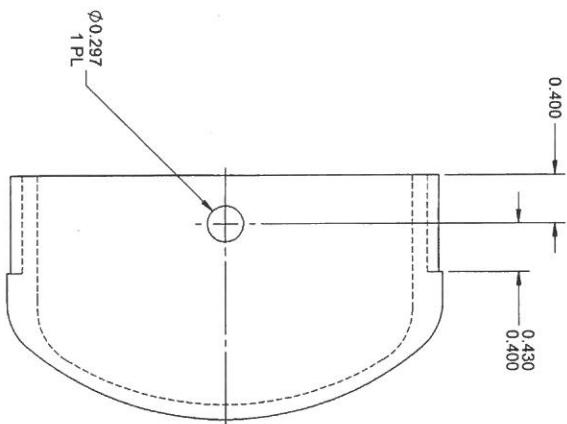
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	WK	HAMKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DC	CAP	NTS
DATE	17.03.01	COPYRIGHT © 1996 BY DART AEROSPACE LTD	

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INSTALL AL-S4-1032-225 (OR AKS7-1032-225 OR
AL-S7-1032-225 OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
1 PL

D2855-5 CAP
(MAKE FROM D2855C CASTING) 

- NOTES:
- 1) MATERIAL: MAKE FROM D2855C
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART OSI 005.4.3
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.50 lbs



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R 2017-05-08

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DESIGN	DS	DART AEROSPACE LTD	
DRAWN	WK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D2855	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CAP	NTS
DATE	17.03.01	COPYRIGHT © 1996 BY DART AEROSPACE LTD	

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